

Work Order ID 144157

Tuesday, April 05, 2016 1:02:12 PM

144157

Page 1

Item ID: D3489-3-200

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Pip Pin

Stop

NS2

Start Date: 4/8/2016 Start Qty: 20.00

20

SPLIT - 1-

Cust Item ID:

Required Date: 4/19/2016 Req'd Qty: 20.00

20

FX

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: APR 05 2016

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3489	Rev A								
100	PURCHASING	0.00							DAS 13 9-89
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>31966</u> P/N: 806206 Possible Supplier: Jergens								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.01							
Packaging	Ensure material certification is attached								
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									

20

APR 07 2016

FX SP16-04-B

7

DAS
38
9-89

APR 14 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition				
					Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
☐ OTHER : _____						

Work Order ID 144157

Tuesday, April 05, 2016 1:02:12 PM

144157

Page 2

Item ID: D3489-3-200

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Pip Pin

Start Date: 4/8/2016 Start Qty: 20.00

20

Cust Item ID:

Required Date: 4/19/2016 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Packaging

Memo

LOCATION : GA

0.00

7 MJS 16-04-15

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.03

MJS APR 15 2016

2m 16/4/15.

MJS APR 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

Tuesday, April 05, 2016 1:02:15 PM

Page 1

Work Order ID: 144157

144157

Parent Item: D3489-3-200

D3489-3-200

Parent Item Name: Pip Pin

Start Date: 4/8/2016

Required Date: 4/19/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 06-03-10 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
806206		Purchased	No			100	Each	0.0000	1	207			
806206									**	7x			
PIP PIN													

SP16-04-13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3489	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE PIP PIN	SCALE NTS
A	06.01.04	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

1) SPECIFICATION: D3489-X-YYY PIP PIN

WHERE 'X' IS THE NOMINAL SIZE IN 1/16THS OF AN INCH
AND 'YYY' IS THE GRIP LENGTH IN TENTHS OF INCHES

FOR EXAMPLE, D3489-3-050 IS 3/16" NOMINAL O.D. WITH 0.50" GRIP

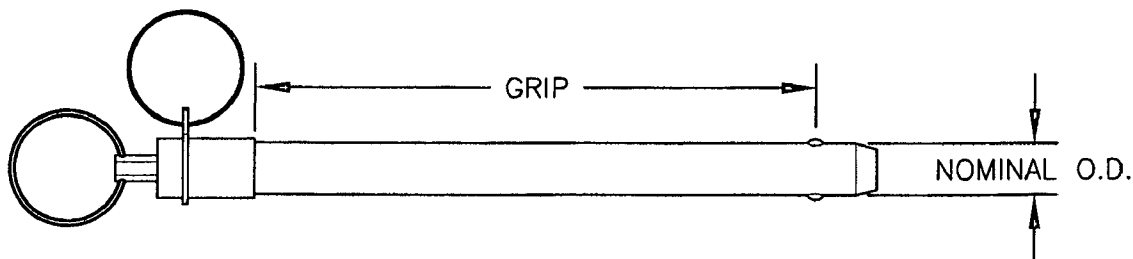
2) ACCEPTABLE SUPPLIERS / PART NUMBERS TO PURCHASE

DART P/N	Nominal O.D.	GRIP	Possible Suppliers	
			JERGENS	REID
D3489-3-050	3/16"	0.50	806200	DARS-000D
D3489-3-075	3/16"	0.75	806201	-
D3489-3-100	3/16"	1.00	806202	DARS-001
D3489-3-125	3/16"	1.25	806203	-
D3489-3-150	3/16"	1.50	806204	-
D3489-3-175	3/16"	1.75	806205	-
D3489-3-200	3/16"	2.00	806206	DARS-004
D3489-3-250	3/16"	2.50	806208	DARS-005
D3489-3-300	3/16"	3.00	806209	-
D3489-4-050	1/4"	0.50	806216	DARS-009
D3489-4-075	1/4"	0.75	806217	-
D3489-4-100	1/4"	1.00	806218	-
D3489-4-125	1/4"	1.25	806219	-
D3489-4-150	1/4"	1.50	806220	DARS-020
D3489-4-175	1/4"	1.75	806221	-
D3489-4-200	1/4"	2.00	806222	DARS-030
D3489-4-250	1/4"	2.50	806224	DARS-035
D3489-4-300	1/4"	3.00	806225	DARS-040
D3489-4-400	1/4"	4.00	808227	DARS-050

3) DESCRIPTION: DOUBLE ACTING, STAINLESS STEEL, QUICK-RELEASE BALL LOCK PINS WITH RING HANDLE

4) MATERIAL: STAINLESS STEEL. MIN. PULL OUT STRENGTH = 200LBS (3/16" PINS) OR 230LBS (1/4" PINS). MIN. DOUBLE SHEAR = 5150LBS (3/16" PINS) OR 9200LBS (1/4" PINS).

5) ALL DIMENSIONS ARE IN INCHES



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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____							
Misidentified ☐	☐	Past Due								



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO31966

Purchase Order Date 4/7/2016

PO Print Date 4/7/2016

Page Number 1 of 2

Order From :

VC-HAS001

Ship To : DART AEROSPACE LTD

HASKINS INDUSTRIAL
5-52 ANTARES DRIVE
NEPEAN, ON K2E 7Z1
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
APR 8 2016

Contact Name

Vendor Phone 613 723 8800

Ship To Contact

Ship To Phone

Ship Via: Dicom

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
Line Comments		Promise Date					
Delivery Comments							
1	806206	PIP PIN	4/13/2016		20.00	\$29.07	\$581.40
			Yes		Each		
			4/13/2016				
AS PER DWG D3489 REV. A		Rec'd 7x \$216 04-13					
B144157							
C OF C REQUIRED							
						Line Total:	\$581.40
2	71500-30	AADE0375J3E K600 CARB END-MILL	4/13/2016		2.00	\$37.97	\$75.94
			Yes		Each		
			4/13/2016				
						Line Total:	\$75.94
Deliver To: CNC							
3	71500-30	NG3M225LK KCU25 INSERT	4/13/2016		13.00	\$18.93	\$246.09
			Yes		Each		
			4/13/2016				

rec'd 4/13/16

Sp16-04-13

PO Instructions: PROCUREMENT QUALITY CLAUSES A000 CLAUSES NOT REQUIRED

Note:

4/7/2016

HASKINS INDUSTRIAL INC.
5-52 ANTARES DRIVE

** PACKING SLIP **

Order # 1261184.00

Order Date 04/07/16

NEPEAN, ONTARIO K2E 7Z1
TEL (613)723-8800 FAX (613)723-8806

Page 1 of 1

Sold To: DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY
ON
K6A 1K7

Ship To: DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY
ON
K6A 1K7

* Reprint *

Cust Phone #	Warehouse	F.O.B.	Taken By
	OTTAWA	DEST	Sylvie 613-723-880

Cust #	Customer P/O #	Required	Orig Order	Slsm	Ship Via	Terms
05168	31966	04/08/16	1261184.00	PL	DICOM	NET 30

Ln#	Bin #	Order UM	Ship	B/O	Product	Description
-----	-------	----------	------	-----	---------	-------------

1		2 EA	2		KEO1X1 3870472	AADE0375J3E K600 CARB EM
---	--	------	---	--	-------------------	--------------------------

2		25 EA	13	12	KEO1X1 4109720	NG3M225LK KCU25 INSERT
---	--	-------	----	----	-------------------	------------------------

3	030220	7 EA	7		JG-806206	3/16 DBL ACTION RING HANDLE 806206
---	--------	------	---	--	-----------	------------------------------------

SP16-04-B

PLEASE NOTE:

1. NO RETURNS WITHOUT PRIOR AUTHORIZATION
 2. ALL SHORTAGE CLAIMS MUST BE WITHIN 10 DAYS
 3. BO CODE: BO = QTY NOT SHIPPED IS BACK-ORDERED
- CL= QTY NOT SHIPPED WAS CANCELLED
SC= ITEM CONSIDERED COMPLETE - NO B/O CREATED

FILL PACK DATE
Printed on 2016-04-11 at 12:31

4/11/16